



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

C3-4-1
Job Sheet 177386



Part No: C3-4-1

Job Qty: 20 ea

Part Name: Load Beam Bushing



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/10/18

Job Tracking No:

Due Date: 5/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-4-1 Rev 4 IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		5/18/18	0.00	0.00	Start Up Machining-4		SL 18-5-16
120	Mori Seiki	20 pcs		5/18/18	0.00	2.00	MORI SL-154		SL
130	QC	20 pcs		5/18/18	0.00	0.00	QC2 Machining-5		SL
140	QC	20 pcs		5/18/18	0.00	0.00	QC8 Machining-5		SL 18/05/17
150	Packaging	20 pcs		5/18/18	0.00	0.00	Packaging3-2		18-05-17 GA-Akin
160	QC21-SA	20 Ea		5/18/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FC038 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 150 - Identify and Stock

DAS
21
9-59

MAY 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.000	Bronze C63000 Round Bar 1.000"	.9320 ft (.0466 ea)	90-Start up Operation	5069340

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.000	1	9	0

Part Specifications

Specifications could not be found.

Plex 5/10/18 9:13 AM Dart.lajeunesse.marie



Container No: S072098



Part: C3-4-1

Job No: 177386

Serial No/Batch: S072098

Revision: 4

Inspector:

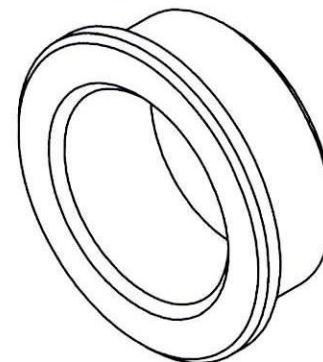
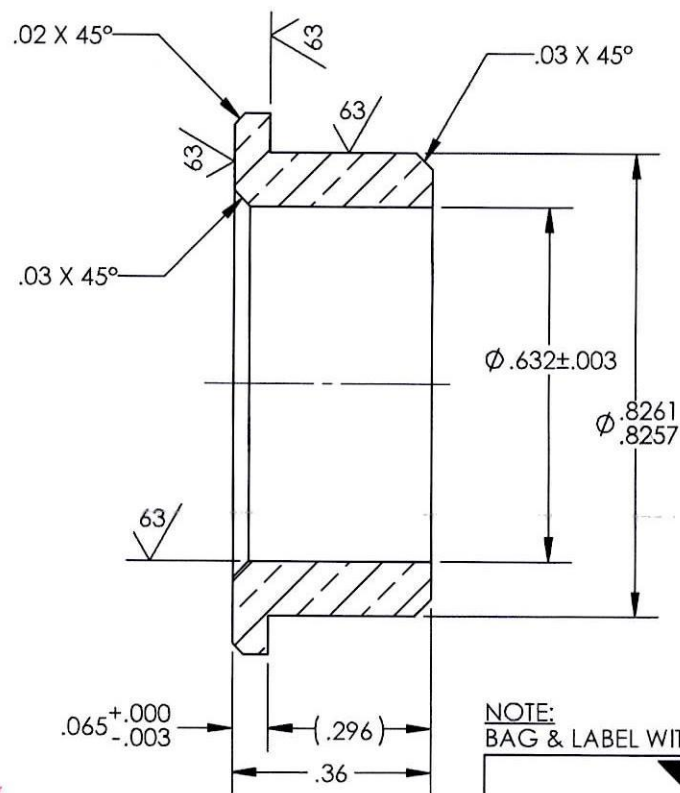
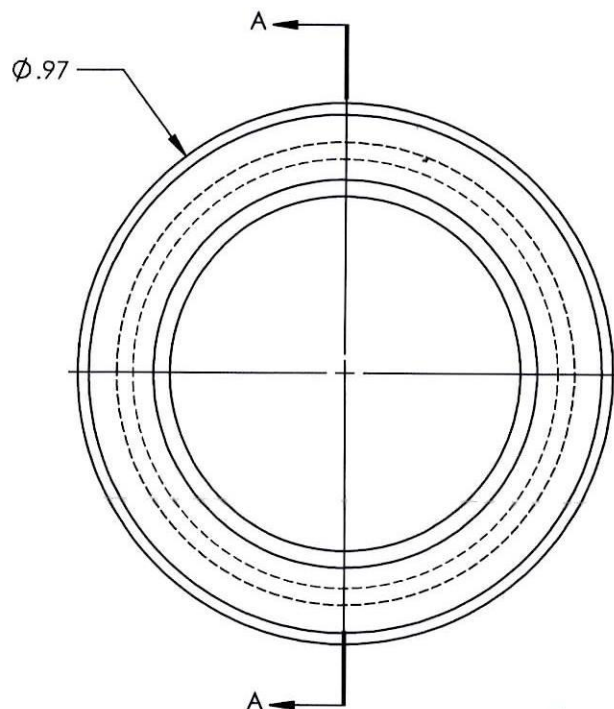
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Date: 05/16/18

DOWN EXHA
PROGRAM
READY FOR FLIGHT

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CHD Ø.825 +.001/.000 TO Ø.8261 - .8257.	8/15/2012	JAG	
3A	14-0111	CHD TITLE BLOCK WAS RED. BARN IS DART. ADDED BAG & LABEL NOTE. CHD DIMENSION TOLERANCE WAS Ø.965 IS Ø.97, WAS .361 IS .36.	8/6/2014	DJN	RW
4	17-0163	CHD MATL WAS AL-BRONZE IS BRONZE 630.	6/23/2017	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 177386

NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOAD BEAM BUSHING	
DWG NO. C3-4-1	REV 4
MATL BRONZE 630	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 06/26/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 06/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 06/28/2017	USED ON MODEL
APPROVED: JAG 07/06/2017	
SCALE 3:1	DATE 11/12/2001 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-4-1	1	LOAD BEAM BUSHING	BRONZE 630	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								